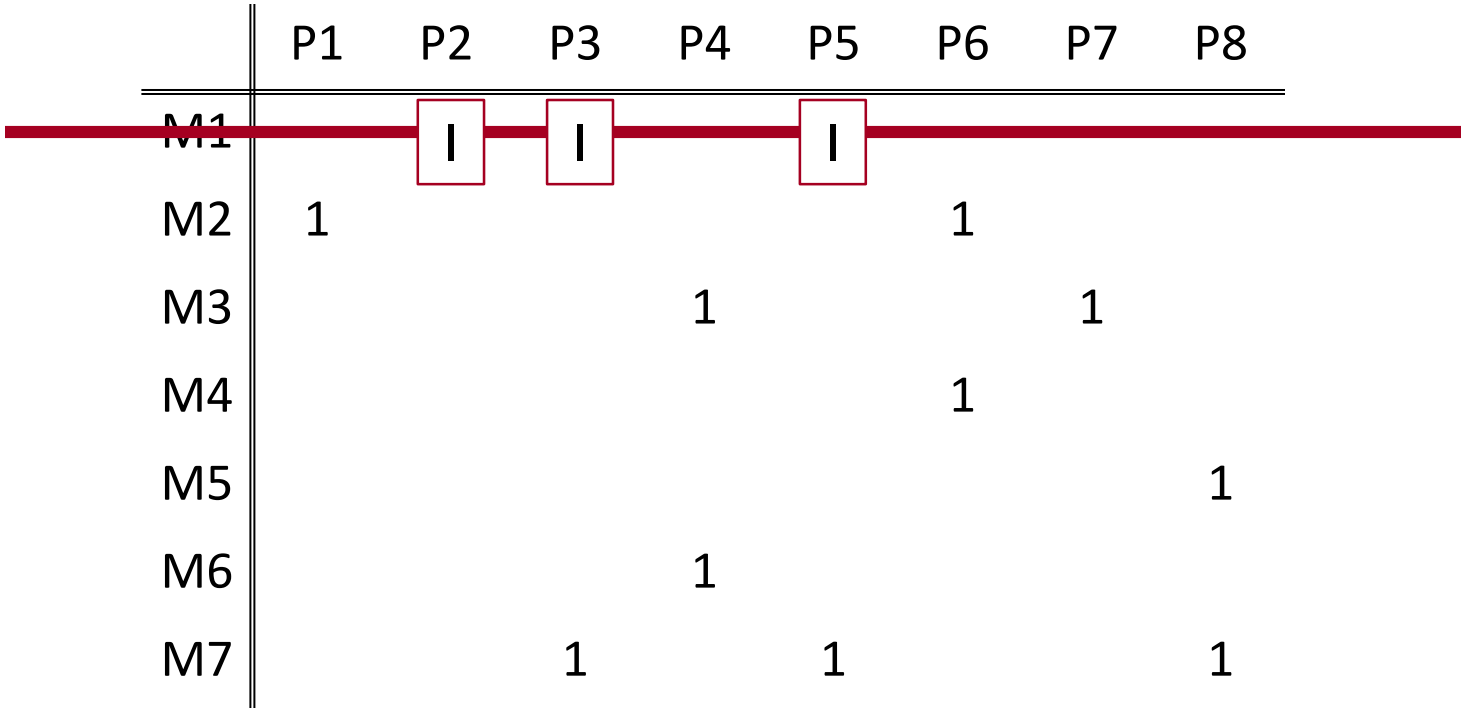
Cluster Identification algorithm

1. Select any row and cross it
2. For each crossed 1 make a vertical line
3. For each crossed 1 make a horizontal line
4. Repeat until all the 1s are crossed by a vertical line or by a horizontal line
5. Form a cell from all the machines and components which were crossed
6. Remove all the crossed elements (machines and components) and start again

Cluster Identification algorithm

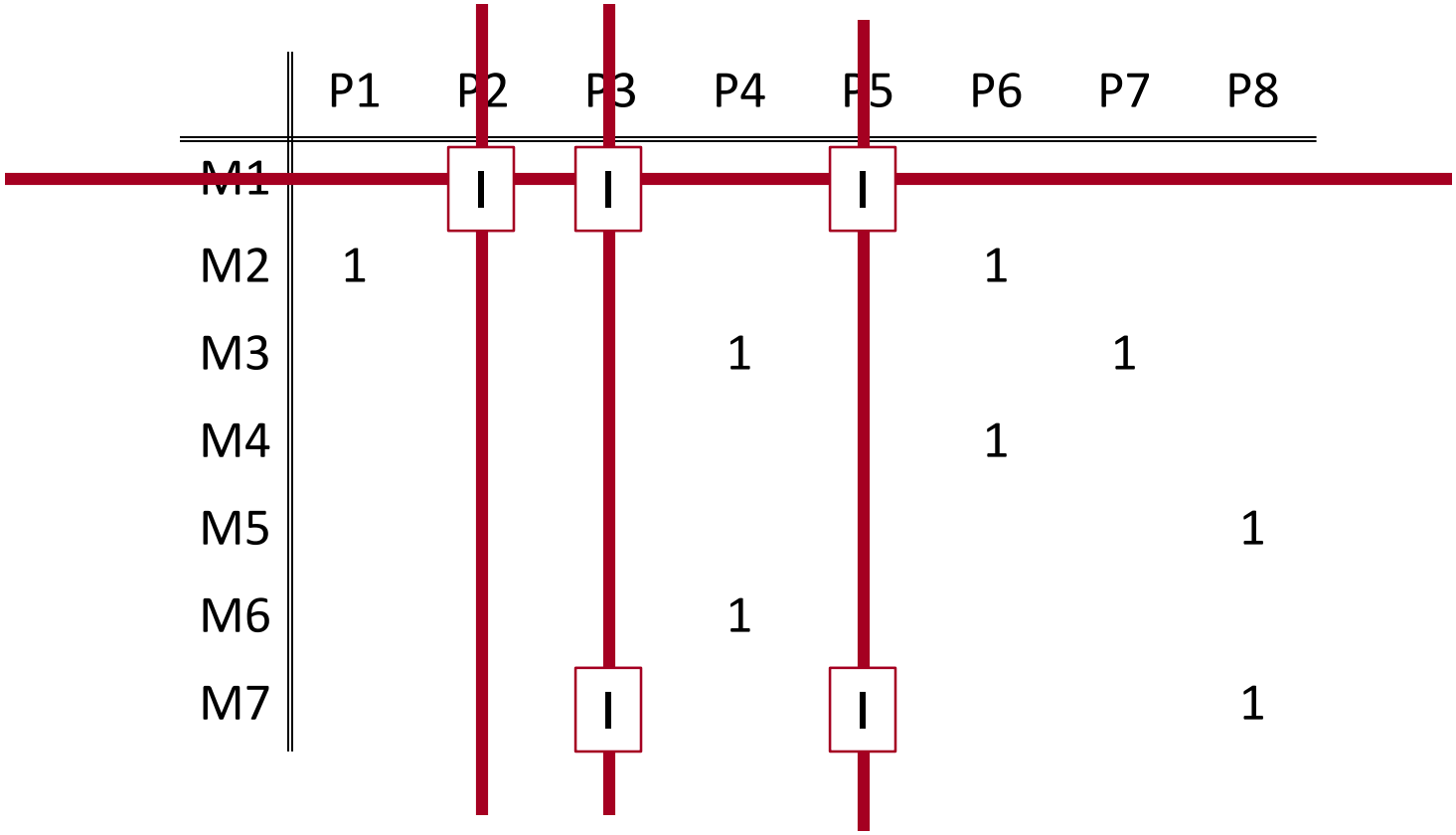
1. Select any row and cross it



	P1	P2	P3	P4	P5	P6	P7	P8
~~M1~~		I	I		I			
M2	1					1		
M3				1			1	
M4						1		
M5								1
M6				1				
M7			1		1			1

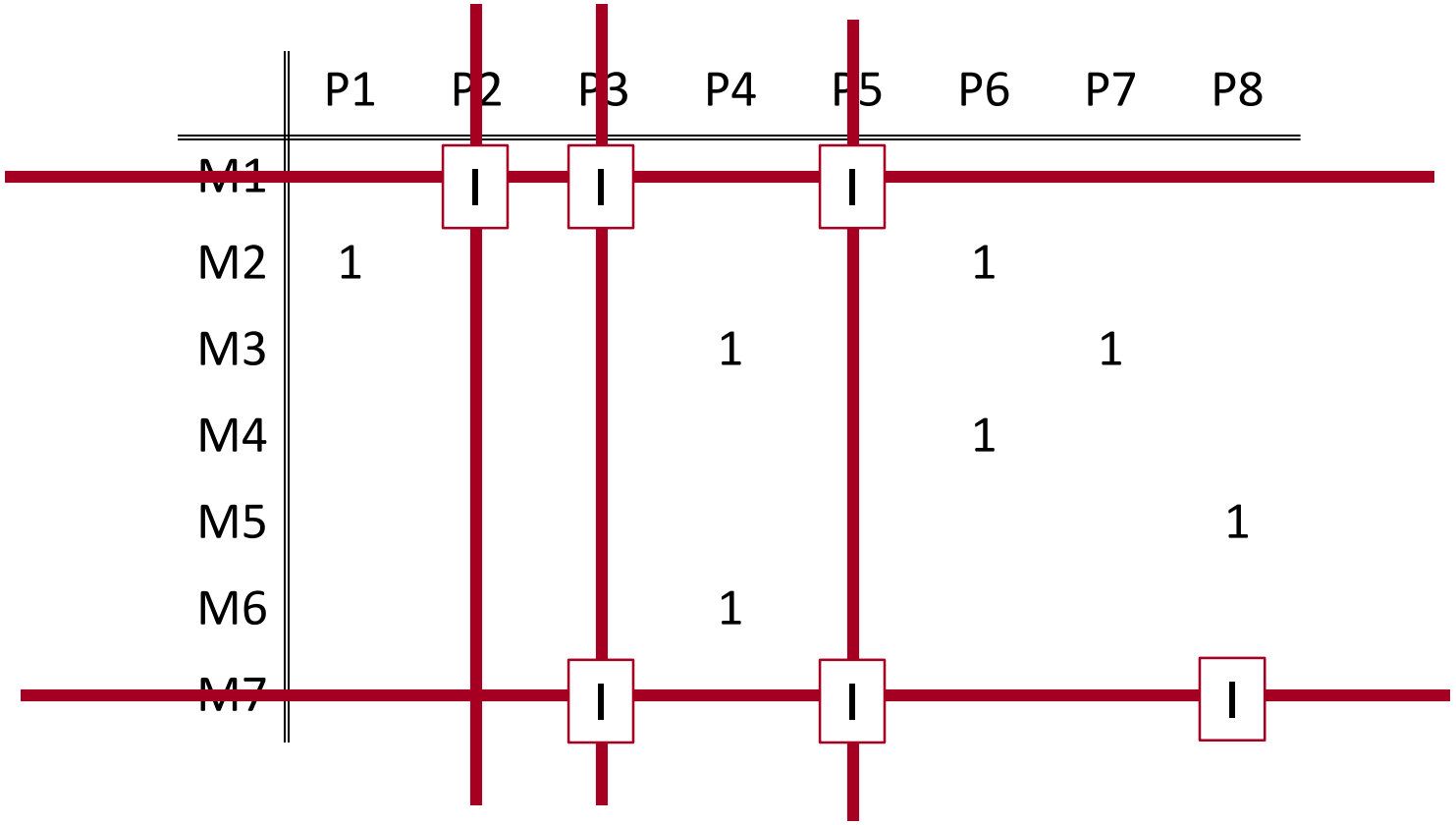
Cluster Identification algorithm

2. For each crossed 1 make a vertical line



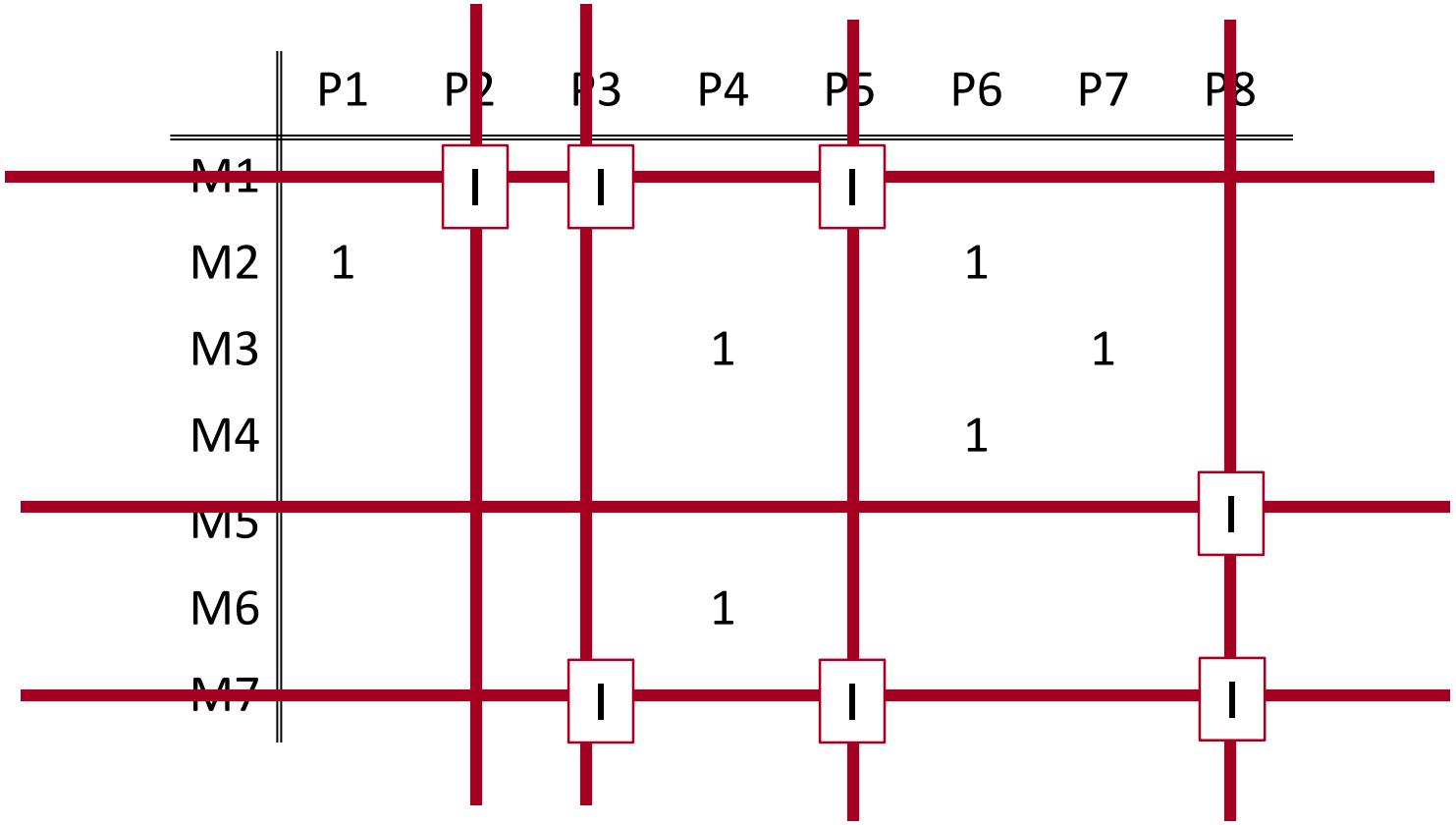
Cluster Identification algorithm

3. For each crossed 1 make a horizontal line



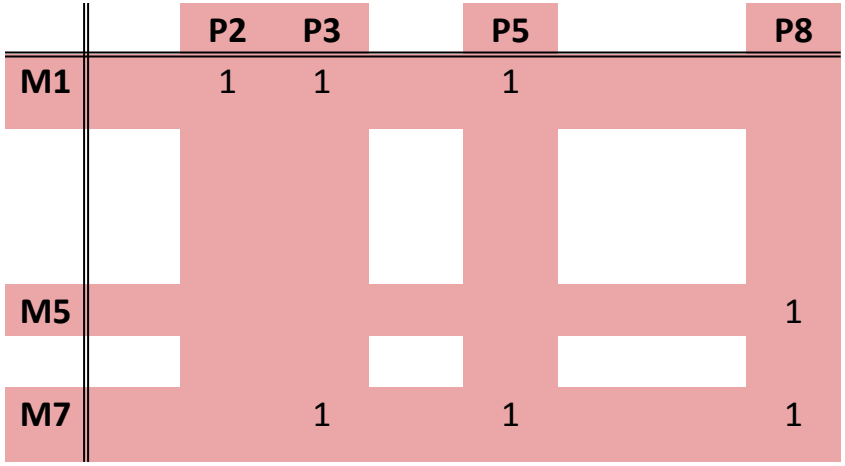
Cluster Identification algorithm

4. Repeat until all the 1s are crossed by a vertical line or by a horizontal line



Cluster Identification algorithm

5. Form a cell from all the machines and components which were crossed

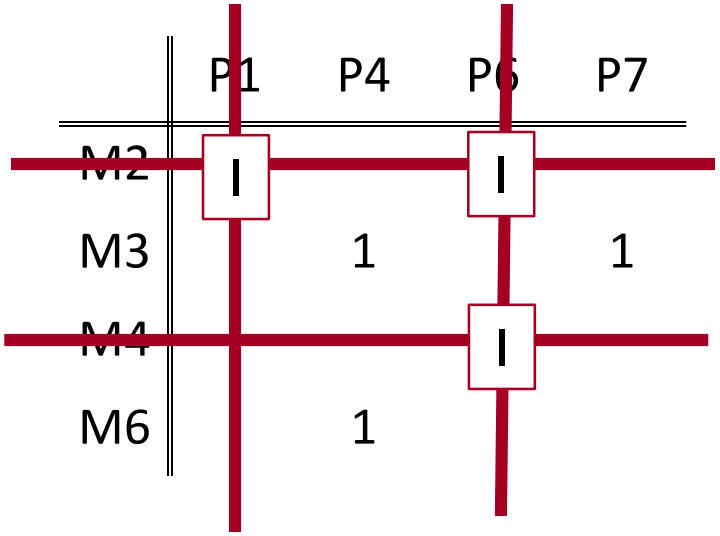


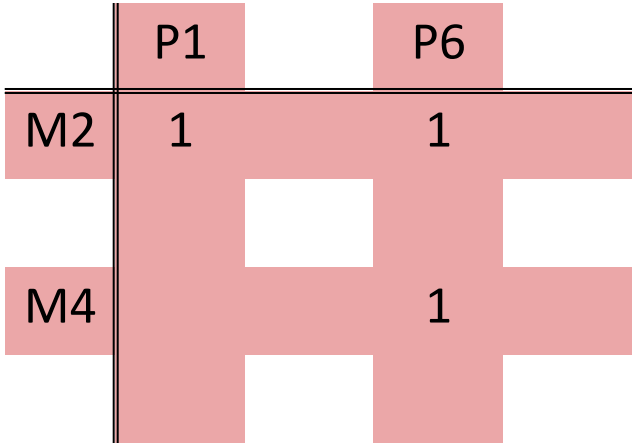
First cell is identified!

Cell #1 will produce parts P2, P3, P5 and P8 with Machines M1, M5 and M7

Cluster Identification algorithm

6. Remove all the crossed elements (machines and components) and start again

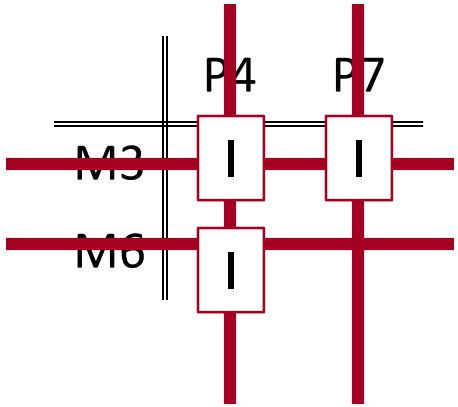




Cell #2 will produce parts P1 and P6 with Machines M2 and M4

Cluster Identification algorithm

6. Remove all the crossed elements (machines and components) and start again



	P4	P7
M3	1	1
M6	1	

Cell #3 will produce parts P4 and P7 with Machines M3 and M6

Cluster Identification algorithm

- Three resulting cells:

